

# Work Order ID 67159

Wednesday, March 09, 2011 12:51:26 PM

Page 1

Item ID: D3508-7

Accept

Revision ID:

Item Name: Wearplate

Setup Start

Stop

Start Date: 3/9/2011 Start Qty: 8.00

Required Date: 3/16/2011 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

11-03-9

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3508

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3508

☐ Dwg Rev:

C

☐ Prog Rev:

C

☐ 2-

Deburr if necessary

B11-3-9

304.046

8

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-3-9

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sulorlop

XS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

Item ID: D3508-7

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 3/9/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 3/16/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC	NC BRAKE	0.00				8			
Brake NC	Memo 1-Form on brake using DT8326 and DT8261 as per Dwg D3508	0.00		50 11/03/10					
140  QC	QC5- Inspect part completeness to step on W/O	0.00				m	11	03	10 (8)
Quality Control	Memo	0.00							
150  Powdercoat	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00				8 BL	11-3-10		
Powder Coating	Memo START TIME: 3:00 FINISH TIME: 3:15 OVEN TEMPERATURE: 3:45	0.00							

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**Work Order ID 67159**

Wednesday, March 09, 2011 12:51:26 PM

Page 3

Item ID: D3508-7

Accept

Revision ID:

Item Name: Wearplate

Start Date: 3/9/2011 Start Qty: 8.00

Required Date: 3/16/2011 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8 0 11/10/11

170

Identify as per dwg & Stock Location: FP-21 0.00

Packaging

Memo

0.00

Packaging

8 11-3-11

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/14

MF  
11-03-11

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, March 09, 2011 12:51:32 PM

Page 1

Work Order ID: 67159



Parent Item: D3508-7



Parent Item Name: Wearplate

Start Date: 3/9/2011

Required Date: 3/16/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 06-06-20 JLM  
IPP Rev:B Now SS as per Rev B 06-12-15 JLM  
IPP Rev:C Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S20GA

Purchased

No

100

sf

90.5938

0.3116

2.624



B11-3-9

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT

90.5938

115953

21.6

116437

38.7538

116623

30.24

116437

8

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	67139
<b>Description:</b> Wearplate		<b>Part Number:</b>	D3508-7
<b>Inspection Dwg:</b> D3508 <b>Rev:</b> C		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.063	+/-0.010	2.068	X		V HB02	
2.813	+/-0.010	2.810	X		V	
Ø0.188	+0.005/-0.001	.192	X		V	
0.375	+/-0.010	.376	X		V	
6.875	+/-0.010	6.875	X		T HB01	
13.750	+/-0.010	13.750	X		T	
16.10	+/-0.030	16.10	X		T	
0.300	+/-0.010	.307	X		V	
0.300	+/-0.010	.308	X		V	
0.040	+/-0.010	.034	X		V	

<b>Measured by:</b> B	<b>Audited by:</b> D	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11-3-9	<b>Date:</b> 11/03/09	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.07	New Issue	KJ/EC	

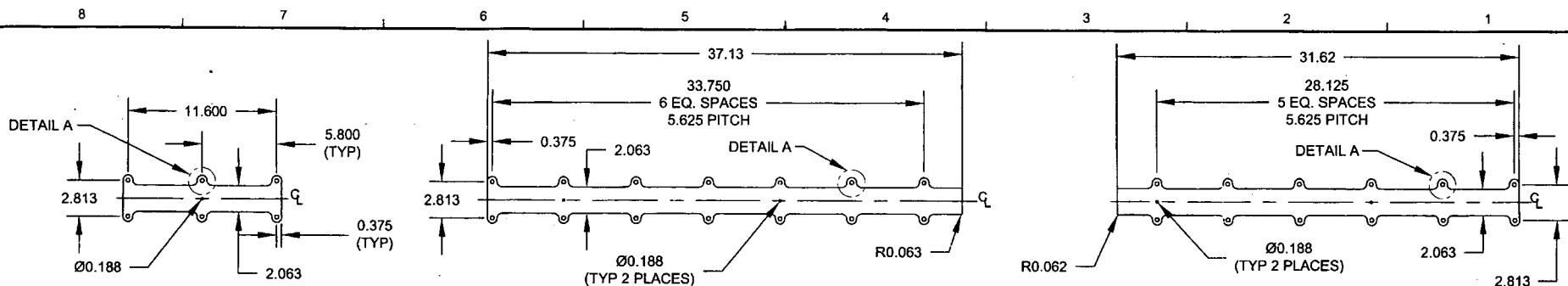
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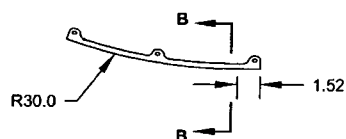
**NOTE:** Date & initial all entries



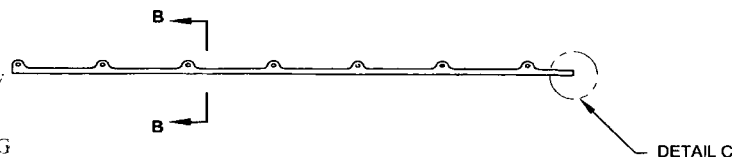
**D3508-1 FLAT PATTERN**

**D3508-3 FLAT PATTERN**

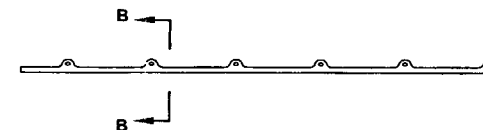
**D3508-5 FLAT PATTERN**



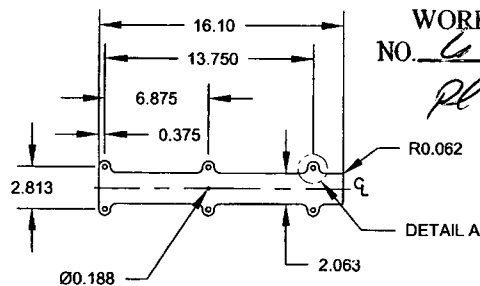
**D3508-1 BENDING DETAIL**  
(MAKE FROM D3508-1F)



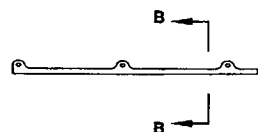
**D3508-3 BENDING DETAIL**  
(MAKE FROM D3508-3F)



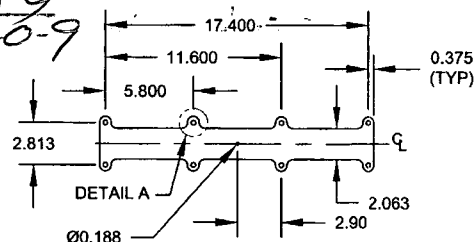
**D3508-5 BENDING DETAIL**  
(MAKE FROM D3508-5F)



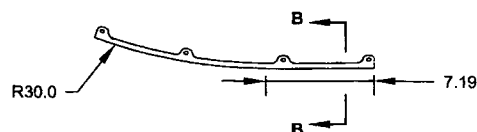
**D3508-7F FLAT PATTERN**



**D3508-7F BENDING DETAIL**  
(MAKE FROM D3508-7F)



**D3508-9F FLAT PATTERN**



**D3508-9F BENDING DETAIL**  
(MAKE FROM D3508-9F)

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,  
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs  
D3508-13 - 0.25 lbs

**RELEASED**  
07.11.16

C	ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.04.20		

**DART AEROSPACE USA, INC**  
PORT HADLOCK, WA  
DRAWING NO. D3508  
TITLE WEARPLATE  
REV. C  
SHEET 1 OF 2  
SCALE 1:8

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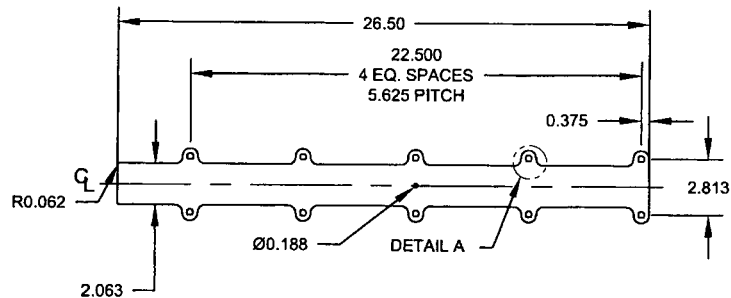
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

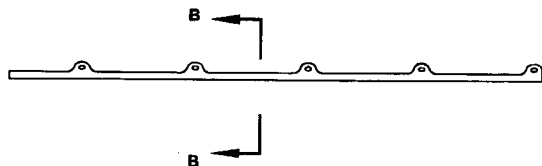
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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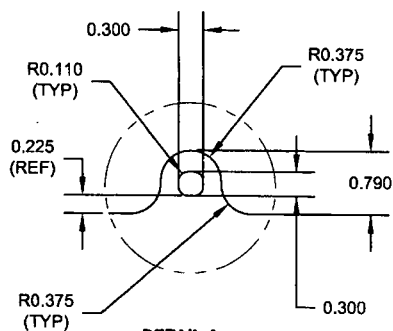
**NOTE:** Date & initial all entries



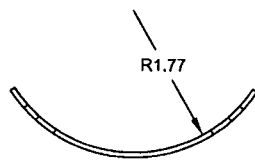
**D3508-11F FLAT PATTERN**



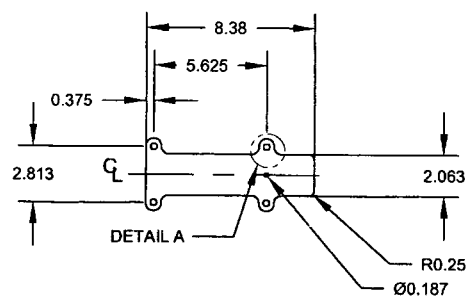
**D3508-11 BENDING DETAIL**  
(MAKE FROM D3508-11F)



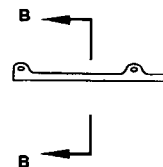
**DETAIL A**  
(SCALE 2:3)



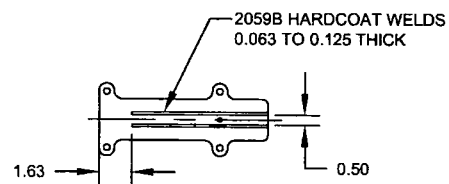
**SECTION B-B**  
(SCALE 2:3)



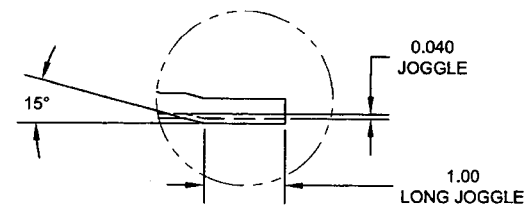
**D3508-13F FLAT PATTERN**



**D3508-13 BENDING DETAIL**  
(MAKE FROM D3508-13F)



**D3508-13 WELDING DETAIL**



**DETAIL C**  
(SCALE 1:2)

RELEASED  
07-11-16

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3508	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARPLATE	1:1
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC	
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